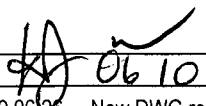
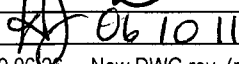


Date: Wednesday, 10/11/2006 12:49:57 PM  
 User: Kim Johnston

## Process Sheet

|                                  |   |                         |   |
|----------------------------------|---|-------------------------|---|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services   | <b>Drawing Name</b>     | : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE |
| <b>Job Number</b>                | : 28937   |                         |   |
| <b>Estimate Number</b>           | : 10831   |                         |   |
| <b>P.O. Number</b>               | : N/A   | <b>Part Number</b>      | : D29321                                |
| <b>This Issue</b>                | : 10/11/2006  | <b>S.O. No.</b>         | : N/A                                   |
| <b>Prsht Rev.</b>                | : NC  | <b>Drawing Number</b>   | : D2932 REV B                           |
| <b>First Issue</b>               | : N/A   | <b>Project Number</b>   | : N/A                                   |
| <b>Previous Run</b>              | : 28858   | <b>Drawing Revision</b> | : B                                     |
|                                  | <b>Type</b> : MACHINED PARTS  | <b>Material</b>         | : N/A                                   |
| <b>Written By</b>                | :  | <b>Due Date</b>         | : 11/6/2006                             |
| <b>Checked &amp; Approved By</b> | :  | <b>Qty:</b>             | 6 Um: Each                              |
| <b>Comment</b>                   | : Est: B 00.06.26 New DWG rev, (mpp 2069) EC  |                         |   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |          |                         |
|-----|----------|-------------------------|
| 1.0 | D6101003 | 7075-T7351 2X6.25X7.875 |
|-----|----------|-------------------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No: 625347

J.L 06/10/16

|     |       |                                |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr & TUMBLE

J.L 06/10/16

|     |               |                              |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.L 06/10/16

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|



**Comment:** INSPECT ALL DIM TO DIM SHEET

J.L 06/10/16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 26/10/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 10/11/2006 12:49:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 28937

Part Number: D29321

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

06/10/18 x 6

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

yl

06/10/18 x 6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 06 10 18 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/10/23 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: ST474

06/10/23 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/23 (6)

Job Completion



06/10/23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|   |                             |
|---|-----------------------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b> 28937    |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> D2932-1 |
| <b>Inspection Dwg:</b> D2932 Rev. B                 | <b>Page 1 of 1</b>          |

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |       |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4     | By | Date |
| A             | 0.100 | 0.140 |                | .121                       | .120  | .121  | .120  |    |      |
| B             | 0.100 | 0.140 |                | .120                       | .119  | .120  | .119  |    |      |
| C             | 0.100 | 0.140 |                | .121                       | .118  | .119  | .117  |    |      |
| D             | 0.210 | 0.230 |                | .220                       | .220  | .220  | .219  |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.249 |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 | 1.250 | 1.250 |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.499 | 2.501 | 2.500 |    |      |
| H             | 0.510 | 0.515 |                | .514                       | .514  | .514  | .514  |    |      |
| I             | 1.572 | 1.582 |                | 1.578                      | 1.577 | 1.577 | 1.577 |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.500 | 2.499 |    |      |
| K             | 0.257 | 0.262 | DT8683         | .258                       | .258  | .258  | .258  |    |      |
| L             | 0.312 | 0.317 | DT8686         | .313                       | .313  | .313  | .313  |    |      |
| M             | 0.235 | 0.240 |                | .238                       | .238  | .238  | .238  |    |      |
| N             | 0.100 | 0.140 |                | .120                       | .120  | .120  | .120  |    |      |
| O             | 0.540 | 0.560 |                | .550                       | .551  | .550  | .550  |    |      |
| P             | 0.490 | 0.510 |                | .499                       | .498  | .498  | .500  |    |      |
| Q             | 3.715 | 3.725 |                | 3.720                      | 3.720 | 3.721 | 3.720 |    |      |
| R             | 2.470 | 2.510 |                | 2.495                      | 2.495 | 2.495 | 2.495 |    |      |
| S             | 0.240 | 0.270 |                | .252                       | .249  | .249  | .249  |    |      |
| T             | 0.100 | 0.180 |                | .140                       | .140  | .140  | .140  |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.630 | 1.630 | 1.630 |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 | 1.367 | 1.367 |    |      |
| W             | 0.316 | 0.321 | DT8690         | .318                       | .318  | .318  | .318  |    |      |
| X             | 1.125 | 1.145 |                | 1.132                      | 1.135 | 1.135 | 1.133 |    |      |
| Y             | 1.565 | 1.585 |                | 1.570                      | 1.573 | 1.571 | 1.570 |    |      |
| Z             |       |       |                |                            |       |       |       |    |      |
| AA            |       |       |                |                            |       |       |       |    |      |
| AB            |       |       |                |                            |       |       |       |    |      |
| AC            |       |       |                |                            |       |       |       |    |      |
| AD            |       |       |                |                            |       |       |       |    |      |
| AE            |       |       |                |                            |       |       |       |    |      |
| AF            |       |       |                |                            |       |       |       |    |      |
| AG            |       |       |                |                            |       |       |       |    |      |
| AH            |       |       |                |                            |       |       |       |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|              |          |
|--------------|----------|
| Measured by: | SL       |
| Date:        | 06/10/15 |

|             |          |
|-------------|----------|
| Audited by: | En       |
| Date:       | 06/10/16 |

| Rev | Date     | Change  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue   | RF         |          |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      |          |

|   |                             |
|---|-----------------------------|
| <b>DART AEROSPACE LTD</b>                           | <b>Work Order:</b> 28937    |
| <b>Description:</b> 206 Saddle, Outboard, Left side | <b>Part Number:</b> D2932-1 |
| <b>Inspection Dwg:</b> D2932 Rev. B                 | <b>Page 1 of 1</b>          |

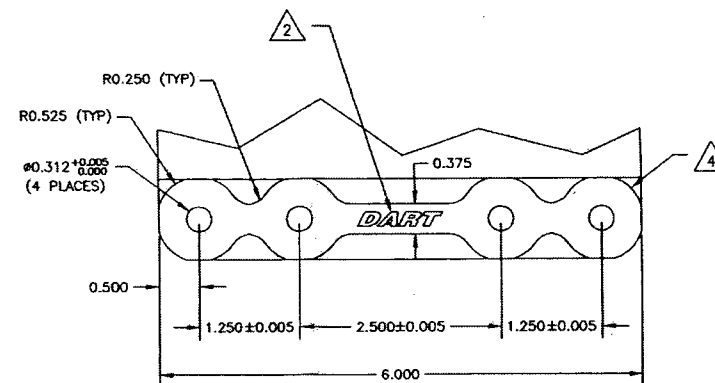
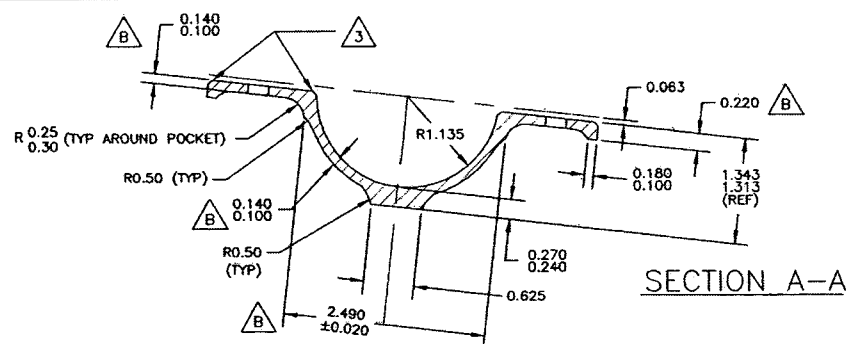
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

|               |       |       |                | Recorded Actual Dimensions |       |   |   |    |      |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3 | 4 | By | Date |
| A             | 0.100 | 0.140 |                | .119                       | .120  |   |   |    |      |
| B             | 0.100 | 0.140 |                | .119                       | .120  |   |   |    |      |
| C             | 0.100 | 0.140 |                | .118                       | .119  |   |   |    |      |
| D             | 0.210 | 0.230 |                | .220                       | .220  |   |   |    |      |
| E             | 1.245 | 1.255 |                | 1.250                      | 1.250 |   |   |    |      |
| F             | 1.245 | 1.255 |                | 1.250                      | 1.250 |   |   |    |      |
| G             | 2.495 | 2.505 |                | 2.500                      | 2.500 |   |   |    |      |
| H             | 0.510 | 0.515 |                | .514                       | .514  |   |   |    |      |
| I             | 1.572 | 1.582 |                | 1.577                      | 1.578 |   |   |    |      |
| J             | 2.495 | 2.505 |                | 2.500                      | 2.500 |   |   |    |      |
| K             | 0.257 | 0.262 | DT8683         | .258                       | .258  |   |   |    |      |
| L             | 0.312 | 0.317 | DT8686         | .313                       | .313  |   |   |    |      |
| M             | 0.235 | 0.240 |                | .238                       | .238  |   |   |    |      |
| N             | 0.100 | 0.140 |                | .121                       | .119  |   |   |    |      |
| O             | 0.540 | 0.560 |                | .550                       | .550  |   |   |    |      |
| P             | 0.490 | 0.510 |                | .501                       | .500  |   |   |    |      |
| Q             | 3.715 | 3.725 |                | 3.721                      | 3.720 |   |   |    |      |
| R             | 2.470 | 2.510 |                | 2.495                      | 2.495 |   |   |    |      |
| S             | 0.240 | 0.270 |                | .250                       | .249  |   |   |    |      |
| T             | 0.100 | 0.180 |                | .140                       | .140  |   |   |    |      |
| U             | 1.625 | 1.635 |                | 1.630                      | 1.629 |   |   |    |      |
| V             | 1.362 | 1.372 |                | 1.367                      | 1.367 |   |   |    |      |
| W             | 0.316 | 0.321 | DT8690         | .318                       | .318  |   |   |    |      |
| X             | 1.125 | 1.145 |                | 1.135                      | 1.135 |   |   |    |      |
| Y             | 1.565 | 1.585 |                | 1.572                      | 1.572 |   |   |    |      |
| Z             |       |       |                |                            |       |   |   |    |      |
| AA            |       |       |                |                            |       |   |   |    |      |
| AB            |       |       |                |                            |       |   |   |    |      |
| AC            |       |       |                |                            |       |   |   |    |      |
| AD            |       |       |                |                            |       |   |   |    |      |
| AE            |       |       |                |                            |       |   |   |    |      |
| AF            |       |       |                |                            |       |   |   |    |      |
| AG            |       |       |                |                            |       |   |   |    |      |
| AH            |       |       |                |                            |       |   |   |    |      |
| Accept/Reject |       |       |                |                            |       |   |   |    |      |

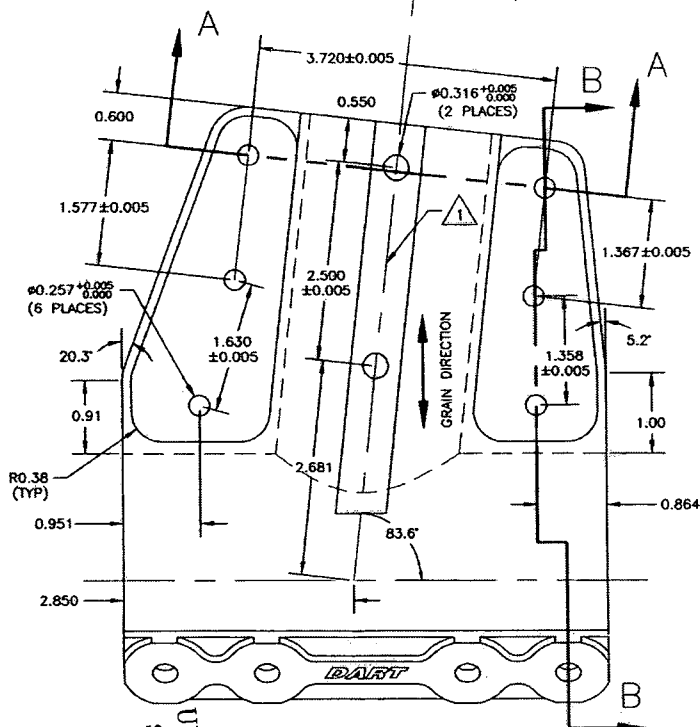
|              |          |
|--------------|----------|
| Measured by: | SL       |
| Date:        | 06/10/15 |

|             |          |
|-------------|----------|
| Audited by: | EP       |
| Date:       | 06/10/16 |

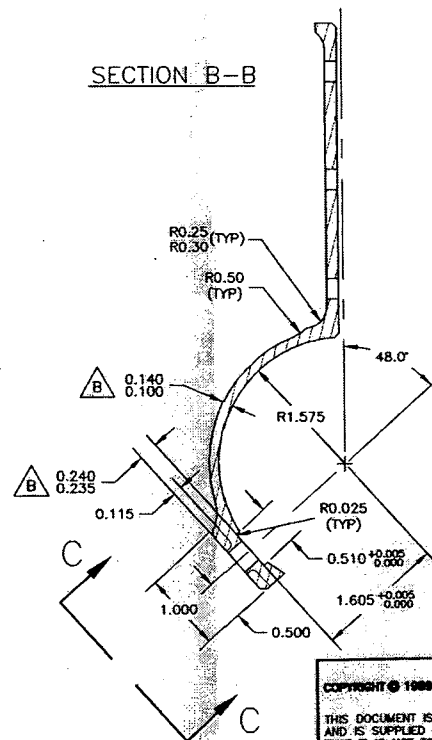
| Rev | Date     | Change  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue   | RF         |          |
| B   | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 | KJ/RF      | #        |



VIEW C-C



SECTION B-B



D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (00-A-250/12)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250
- 3 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.050" x 45°

RELEASED  
00.05.29



|         |          |  |
|---------|----------|--|
| B       | 00.05.29 | CHANGED GEOMETRY AND MATERIAL                          |
| A       | 99.10.29 | NEW ISSUE  |
| DESIGN  | DRAWN BY | <b>DART</b> DART AEROSPACE USA, INC.<br>BELLINGHAM, WA |
| CHECKED | APPROVED | DRAWING NO. D2932                                      |
| DATE    | 00.05.29 | TITLE SADDLE OUTSIDE                                   |
|         |          | REV. B<br>SHEET 1 OF 1<br>SCALE 2:3                    |

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